#### Work Order ID 59979

Tuesday, June 22, 2010 10:16:04 AM



Page 1

Item ID: D3929-042 Accept Setup Start Revision ID: Stop Item Name: Gusset Assembly Start Date: 6/22/2010 Start Oty: 6.00 **Cust Item ID:** Required Date: 7/20/2010 Req'd Qty: 6.00 **Customer:** Reference: Run Start Process Plan: Date: 10-6-22 Tooling: Approvals: Date: : Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Qty Code **Qty** Number Stamp Draw Nbr **Revision Nbr** D3929 Α 100 0.00 B10-6-23 Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg D3929 361. HOS Dwg Rev: Prog Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00

Quality Control

QC

Memo

0.00

B10-6-33

Dart	Aeros	pace	Ltd
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W/O:			W	ORK ORDER CHANG	GES				
DATE	STEP	PROC	CEDURE CHANGE By Date			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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DATE	STEP	Description of NC	Description of NC Corrective Action Section B			Veri	fication	Approval	Approval
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#### Work Order ID 59979

Tuesday, June 22, 2010 10:16:04 AM



Page 2

Item ID:

D3929-042

Accept



Setup Start

Stop



**Revision ID:** 

Item Name: Gusset Assembly

**Required Date: 7/20/2010** 

**Start Date:** 

6/22/2010

Start Oty: 6.00

Req'd Qty: 6.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Set Up/

**Run Hours** 

Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Stop

Reject Insp. Number Stamp

**Work Center ID** 

120

Sequence ID/

Quality Control

**Operation** Description

QC8- Inspect parts - second check

Memo

10/06/23

0.00

0.00

140



Large Fab

Memo

Weld bushings D3907-1 as per dwg D3929

316L rod batch: 111679

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Quality Control

Memo

0.00

B 10.01 06

W/O:			W	ORK ORDER CHANG	iES				
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Work	Orde	r ID	59979	)
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Tuesday, June 22, 2010 10:16:04 AM



Page 3

Item ID:

D3929-042

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

**Gusset Assembly** 

**Start Date:** 

6/22/2010

Start Qty: 6.00

Required Date: 7/20/2010

QC:

Req'd Qty: 6.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date: **Tooling:** 

Date: \_\_\_\_\_

SPC (Y/N):

Set Up/

**Run Hours** 

Date: Date:

Run 1 Start



Sequence ID/ **Work Center ID** 

160 

Operation Description

QC5- Inspect part completeness to step on W/O

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Stop

Reject Number Stamp

Insp.

Quality Control

170

Packaging

Packaging

Memo

Memo

Identify as per dwg & Stock Location: WA

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10-#-04

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W/O:			W	ORK ORDER CHANG	ES					
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Tuesday, June 22, 2010 10:16:08 AM

Work Order ID: 59979

Parent Item:

D3929-042

Parent Item Name: Gusset Assembly

Manufactured

No



114488

114799

**Start Date:** 6/22/2010

Start Qty: 6.00

Required Date: 7/20/2010

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	139.2059	0.45	2.842105	1810-6	- 23	
				Location		Loc	<u>Qty</u>	Loc Code		1			
				MAT		139.	2059				/	. )	

D3907-1

Bushing

<b>Location</b>	Loc Qty	Loc Code
WA	44	
57937	4	
59186	40	

130

11.2059

128

Each 1

44.0000

114488

12

Dart Aerospace	Ltd:
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W/O:			WC	RK ORDER CHANG	ES				**************************************
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DART AEROSPACE LTD	Work Order:	39979
Description: Support Gusset	Part Number:	D3929-1
Inspection Dwg: D3929 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

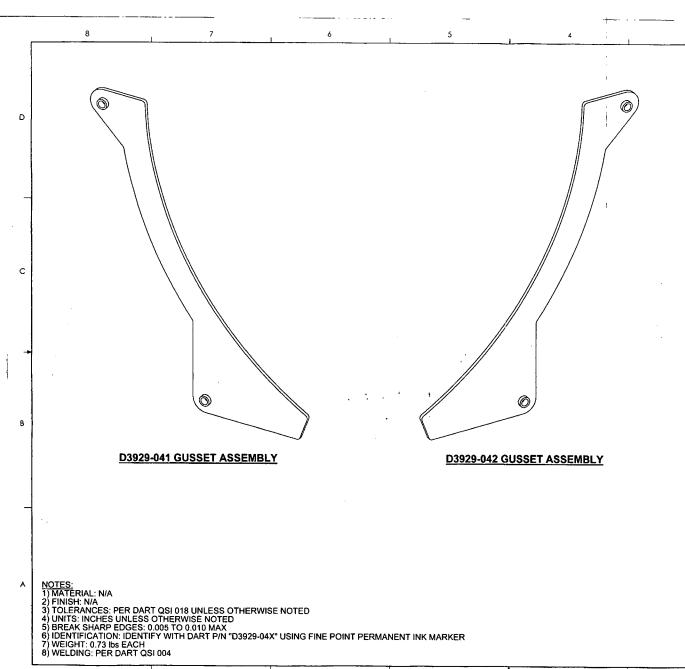
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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Measured by: 15	Audited by:	Prototype Approval:	N/A
Date: 10-6-32	Date: 1066 73	Date:	N/A

Rev	Date	Change		Revised by	Approved
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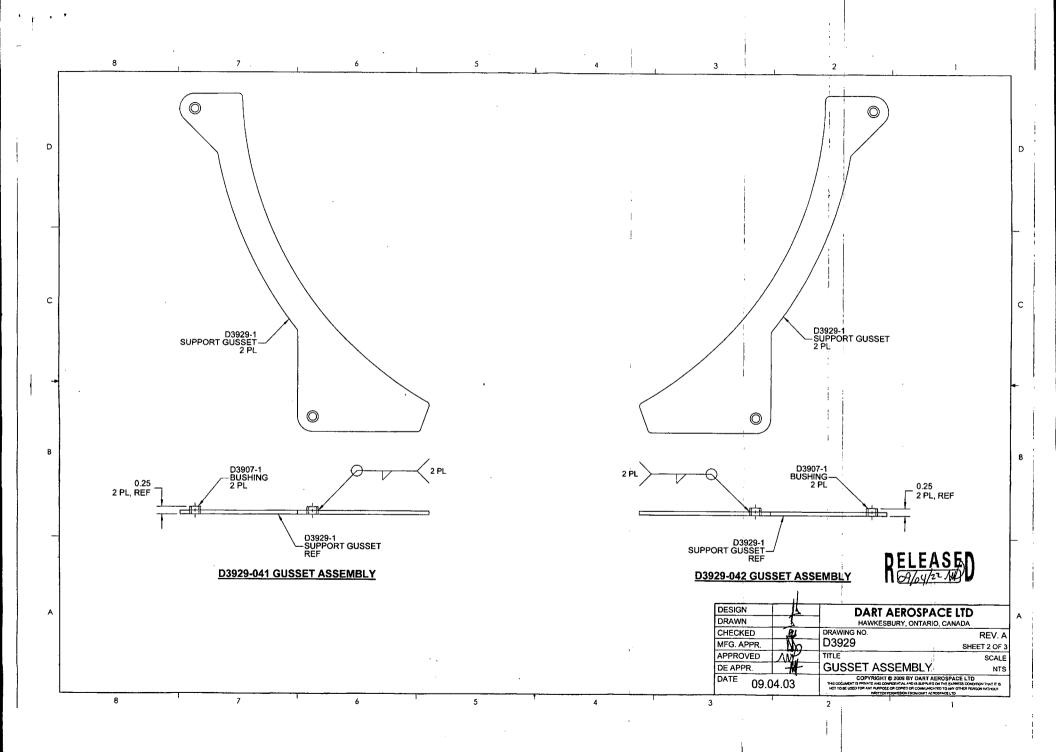


QTY -042 ITEM DESCRIPTION D3929-041 D3929-042 GUSSET ASSEMBLY
GUSSET ASSEMBLY D3907-1 11 BUSHING 12 D3929-1 SUPPORT GUSSET

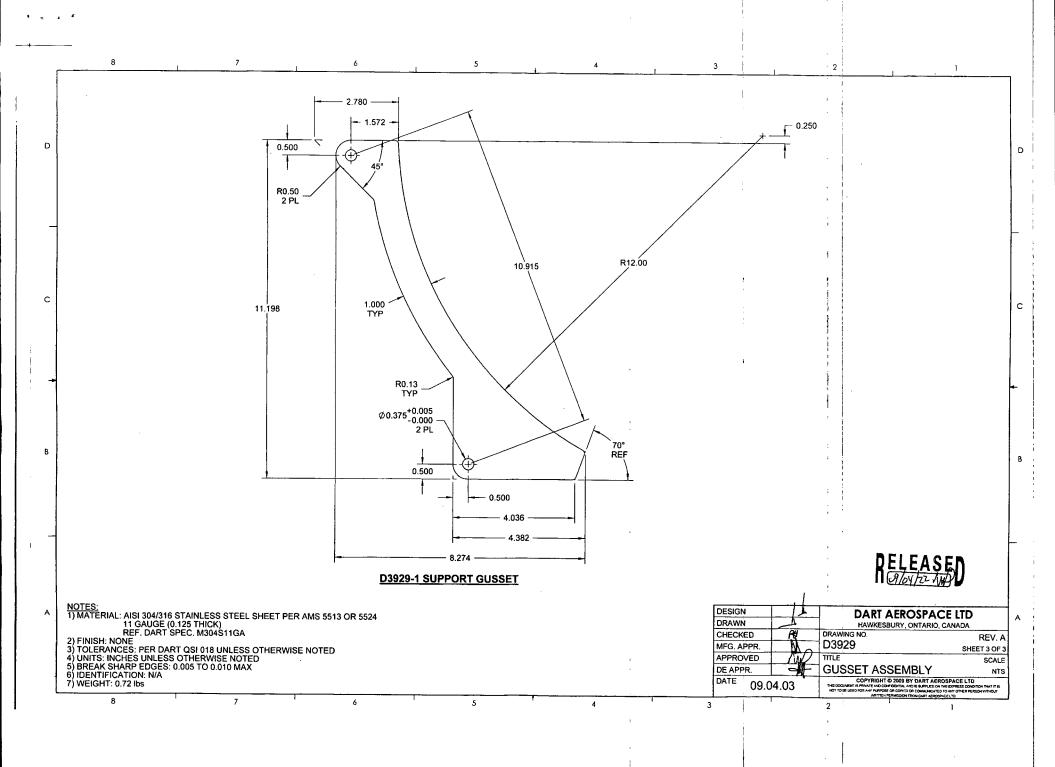
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REV.	1	.1	DESCRIPTION	BY	DATE					
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DE APPR.			GUSSET ASSEMBLY							
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